

Work Order ID 79511

79511

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January-26-12 4:05:40 PM

Item ID: D2667-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle, LH Aft Out 206
 Start Date: 26/01/2012 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 09/02/2012 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: M.L.3 Date: 12/01/24 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2667	Rev D								

100 HAAS CNC VERTICAL MACHINING #1 0.00
100 F.K. 12/03/23 4 0
 HAAS 1 Memo 0.00
 HAAS CNC vertical machine #1 Program batch number.1-Inspect part number and batch number are
 programmed correctly.3-Fixturing Inspection last completed on 12/03/24 by
 4-Machine Step No 1 of Folio and visually inspect as per attached
 Dimension Sheet 5-Machine Step No 2 of F

110 CONVENTIONAL MILLING MACHINE 0.00
110 F.K. 12/03/23 4 0
 Mill Conv Memo 0.00
 Conventional Milling Machine Machine Keyway and inspect per attached dimension sheet 12/03/24

120 QC2- Inspect parts off machine FAI/FAIB 0.00
120 F.K. 12/03/23 4 0
 QC Memo 0.00
 Quality Control 12/03/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

79511

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N900040100

Setup Start *NS1*

Stop *NS2*

4

Cust Item ID:

4

Customer:

Reference:

Run Start *NR1*

Stop ***NR2***

0.00

130

QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.00

Hand Finishing

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

150

Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

1640 FINISH TIME:

370° 12

W/O:		WORK ORDER CHANGES					
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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							
160									
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location 427	0.00							
170									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

12-03-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

January-26-12 4:05:45 PM

Page 1

Work Order ID: 79511

79511

Parent Item: D2667-1

D2667-1

Parent Item Name: Saddle, LH Aft Out 206

Start Date: 26/01/2012

Required Date: 09/02/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: C00.11.01Removed P/O for Powder Coat - in house processEC
IPP Rev:D As per Rev D 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D6101-003		Manufactured	No			100	Each	120.0000	1	4			
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D6101-003

Saddle Billet, 7075

Location	Loc Qty	Loc Code
MAT040	126	
73775	2	
73780	7	
78159	54	
78599	56	
MAT042	-7	
MAT044	1	
73769	1	

80765

4

1-FK 12/03/23

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 79511
Description: 206 Saddle, Outboard, Left side	Part Number: D2667-1
Inspection Dwg: D2667 Rev. D	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2667 Rev. D and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No.Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.123	0.120	0.120	0.120		
B	0.100	0.140		.130	0.130	0.130	0.130		
C	1.125	1.145		1.1354	1.135	0.135	1.137		
D	0.615	0.685		.660	0.670	0.670	0.670		
E	0.240	0.260		.253	0.253	0.253	0.253		
F	1.313	1.343		1.327	1.327	1.327	1.327		
G	0.210	0.230		.223	0.220	0.220	0.220		
H	0.100	0.180		.135	0.135	0.135	0.135		
I	2.470	2.510		2.490	2.490	2.490	2.490		
J	1.565	1.585		1.5745	1.5745	1.5745	1.575		
K	0.235	0.240		.237	0.237	0.237	0.238		
L	0.100	0.120		.109	0.113	0.113	0.113		
M	0.990	1.010		1.002	1.002	1.002	1.003		
N	0.510	0.515		.512	0.512	0.512	0.512		
O	5.990	6.010		6.000	6.000	6.000	6.000		
P	1.245	1.255		1.250	1.249	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.313	0.318		.314	0.314	0.314	0.314		
S	0.315	0.322		.316	0.316	0.316	0.316		
T	1.995	2.005		2.000	1.999	2.000	2.000		
U	1.357	1.367		1.362	1.362	1.362	1.362		
V	0.787	0.807		.796	0.792	0.794	0.795		
W	1.040	1.060		1.050	1.050	1.050	1.050		
X	1.674	1.679		1.679	1.678	1.679	1.679		
Y	0.257	0.262		.260	0.260	0.260	0.260		
Z	0.912	0.932		.922	0.929	0.926	0.926		
AA	0.490	0.510		.500	0.500	0.500	0.500		
AB	0.178	0.198		.189	0.188	0.198	0.188		
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: FK	PO/
Date: 12/03/23	

Audited by: B.A.
Date: 12/03/24

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

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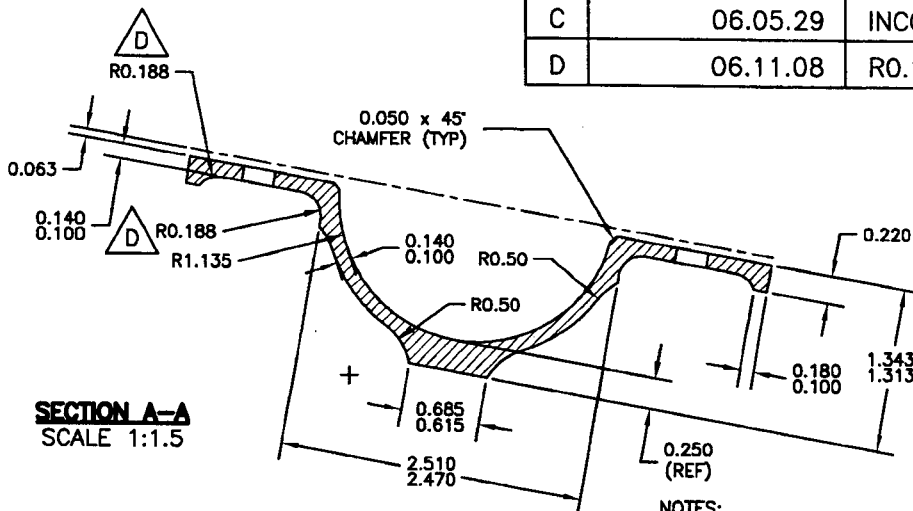
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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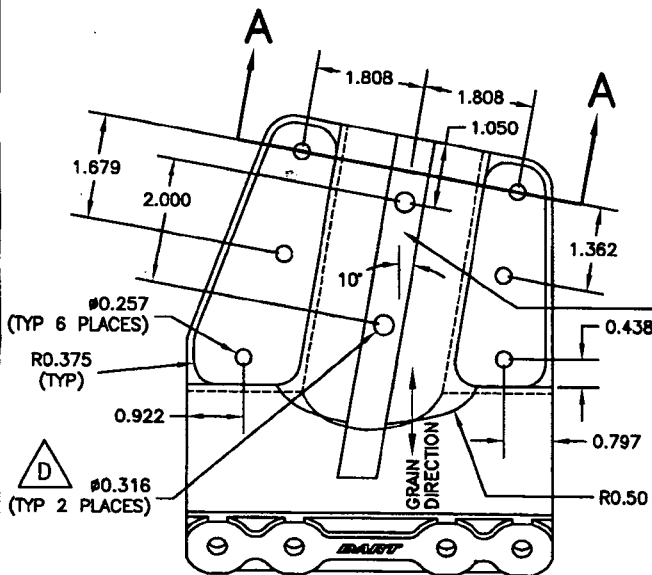
NOTE: Date & initial all entries

DART

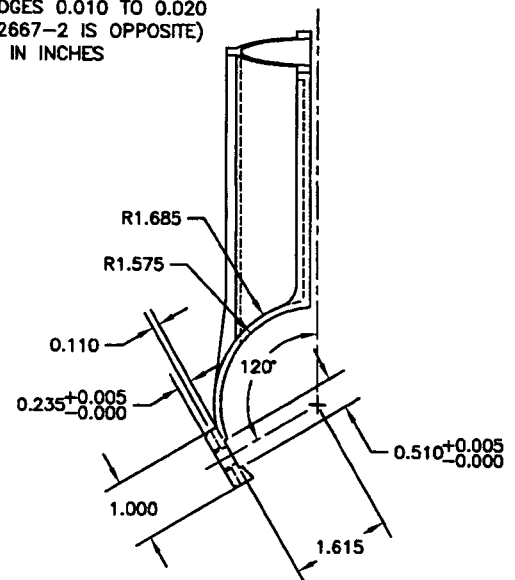
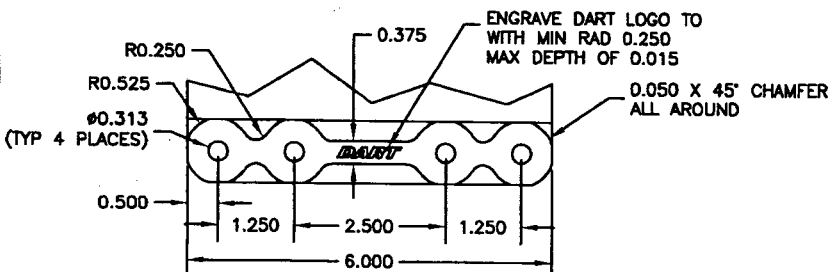
DESIGN #	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED #	DRAWING NO. D2667	REV. D SHEET 1 OF 1
DATE 06.11.08		TITLE SADDLE AFT OUTSIDE HIGH	SCALE 1:3
A	97.03.25	NEW ISSUE	
B	97.07.11	ANGLE AND NOTES ADDED	
C	06.05.29	INCORPORATE DEO 9122, 9102, 9095	
D	06.11.08	R0.188 WAS R0.30; Ø0.316 WAS Ø0.313	

**NOTES:**

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-003 SADDLE BILT, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) D2667-1 SHOWN (D2667-2 IS OPPOSITE)
- 6) ALL DIMENSIONS ARE IN INCHES



ENGRAVE PART
NUMBER AND
BATCH NUMBER
TO MAX DEPTH
OF 0.010 WITH
MIN RADIUS
OF 0.010

**D2667-1 SADDLE AFT OUTSIDE HIGH****Copyright © 1997 by DART AEROSPACE USA, INC.**

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